

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014878**Date Inspected:** 21-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shnanghai, China**CWI Name:** You Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, William Clifford was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly

ZPMC personnel performed weld repair on temporary attachment removal area of South Shaft Lift 1 located on Skin B (47.6M Elevation). The base metal repair areas were approximately 3mm depth and 100mm, 85mm length at random locations. The material is A/709M Grade 345 Non-SPCM. Welder is identified as 500363. ZPMC QC is identified as Mr. Zhu Feng. SMAW welding was been performed per temporary weld repair report. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-Repair.

Bay 11 – Tower Shop

ZPMC qualified welding personnel identified as 046704 and 040656 performing Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-143M-1-5B, 74A, ZPMC CWI Identified as Yu Dong Ping, The welding variables recorded by QC appeared to comply with WPS-B-T-3212Tc-U5b-1.

ZPMC qualified welding personnel identified as 040619 and 040690 performing Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as WD1-STSA4-5-119M-1-6A, 48B, ZPMC CWI Identified as Yu Dong Ping, The welding variables recorded by QC appeared to comply with WPS-B-T-3212Tc-U5b-1.

ZPMC qualified welding personnel identified as 040723, 040704, 049541 and 040759 performing Flux Core Arc Welding (FCAW) on Shear plate bearing stiffener weld. Joint identified as WD1-A25B/B-29, 17, 9, 3. ZPMC QC

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Identified as Xu Jie. The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 1500-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
